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**DESCRIPTION:**

The *CYNERGY 6500 SERIES* are black, highly toughened, high peel strength products ideal for bonding dissimilar materials with excellent performance on a wide range of surfaces. They impart superior vibration, impact and thermal cycling resistance making them ideal for high stress applications.

**TYPICAL PROPERTIES:**

All properties given are at 25 °C unless otherwise noted.

Product	Base	Color	Gap fill (mil)	Viscosity (cps)	Shear strength (psi)*	Temp range °F	Cure Speed (fixture / full cure)	S.G.
CA6501	Ethyl	Black	8	300	3750	-65 to 250	>10 seconds/ 8 hours	1.10
CA6502	Ethyl	Black	9	1000	3750	-65 to 250	>12 seconds/ 8 hours	1.10
CA6503	Ethyl	Black	10	4000	3750	-65 to 250	>18 seconds/ 8 hours	1.10
CA6504	Ethyl	Black	12	10000	3500	-65 to 250	<20 seconds/ 8 hours	1.10

\* Strength values given are: (tensile / steel lap shear)

**PREPARATION:**

For best results and optimum adhesive performance, surface should be clean and free from contaminant. Contaminants can be removed by using suitable solvents. When using a cleaning solvent, first check for material compatibility particularly in case of plastics. An easy method for removing contaminants is by using a clean soft cloth and wiping the surface with acetone or alcohol.

**APPLICATION:**

The *CYNERGY SERIES* of the cyanoacrylates should be applied in small amounts to one surface only. The parts should then be mated together under slight pressure. This causes the adhesive to spread out into a thin film and assures optimum adhesive performance. The pressure need only be applied for several seconds. The *CYNERGY SERIES* cures rapidly allowing for bonded parts to be handled within 10 to 60 seconds for most applications. Full cure is normally within 24 hours.

**SHELF LIFE:**

All of the *CYNERGY SERIES* products have a shelf life of one year when stored at 40 °F. Shelf life at room temperature (72°F) is a minimum of six (6) months. When stored in a refrigerator, allow the adhesive to gradually warm to room temperature prior to use. Avoid heat, direct sunlight and high moisture areas when storing. Avoid contaminating open containers. Do not return unused adhesive to original container. DO NOT refrigerate open containers.